Work Order ID 55680

January 27, 2010 11:25:53 AM



Page 1

Item ID:

D3573-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Required Date: 2/05/10

Adapter

1/27/10

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date: 16-1-27

Tooling:

Date:

Run

Start

Stop

QC:

Date:_____

SPC (Y/N):

Date:

Draw

Sequence ID/ **Work Center ID** Operation Description Set Up/ **Run Hours** Draw Number Rev. Plan Code

Accept Qty

Reject Qty

Number Stamp

Draw Nbr

Revision Nbr

D3573

Rev A

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 3.500" long

0.00

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

0.00

Machine as per Folio FA672 and Dwg D3573

120

QC

QC2- Inspect parts off machine FAI/FAIB

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

M 10.10.29

Memo

Quality Control

Dart Aerospace	Ltd
----------------	-----

	. oopaot	, = tu							· ·
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	DER NON-CONFORMA	NCE (NCI	٦)			
DATE	STEP	Description of NC		on B	Cian e Verifica			Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Date		ion C	Approval Chief Eng	QC Inspector
			•						
								1	
							. :		£
	1	1			,			•	.

Page 2

January 27, 2010 11:25:53 AM

Item ID:

D3573-1

Revision ID:

Item Name:

Start Date:

1/27/10

Adapter

Required Date: 2/05/10

Start Qty: 10.00 Req'd Qty: 10.00



Accept



Run

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date: _____

Date:

Start

Stop



Sequence ID/ **Work Center ID**

130

Quality Control

Operation Description

QC8- Inspect parts - second check

QC: Date: ____

Memo

Set Up/ **Run Hours**

Number

Draw Rev.

Plan Code Accept Qty

Reject Oty

Reject Number Stamp

Insp.

Chemical Conversion Coat per QSI005 4.1

0.00 bf 10-02-01

BP 10/01/09

Memo

Hand Finishing

HandFinish

150

140

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3
***ILZ 588**

0.00

=) Il 10-02-03

X.10 6

Memo

6:45 proven temperature: TIME: 320 F START TIME: 6:4

	•													
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
					:									
			,											
Part No				EDURE CHANGE By Date Qty Chief Eng / Prod Mgr Approach QC Inspection Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: DRK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B- Verification Approval Approach Approach Approach Approval Approval Approach Approval Approach Approach Approval Approach Ap										
	Res	solution:	Disposition	n:	_ QA:	N/C Clo	sed:		Date: _):				
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)							
DATE	STEP	Description of NC			ion B		Verific	ation	Approval	Approval				
DAIL	JILF	Section A					Section C			QC Inspector				

Work Order ID 55680

Page 3

January 27, 2010 11:25:53 AM

Item ID:

D3573-1

Accept

Setup Start

Revision ID:

Start Date:

Item Name:

Adapter

1/27/10

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Process Plan:

Date: __

Tooling:

Date:

Run

Start

Stop

Stop

Approvals:

Required Date: 2/05/10

_____ Date: ___

SPC (Y/N):

Set Up/

Run Hours

Date: ___

Number

Draw Plan

Accept Code Qty

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

Rev.

170

Packaging

Memo

0.00

0.00

Packaging

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Dart	Aer	ospa	ce l	Ltd
------	-----	------	------	-----

	• ,								,					
W/O:			WORK ORDER CHANGES											
DATE	STEP	PR(OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
W														
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	Date:						
	Res	solution: QA: N/C Closed:						Date: _						
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE (NCF	₹)								
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval					
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector					
						:								
<u>.</u>					,									
						i i			ļ					
					, , , , , , , , , , , , , , , , , , , ,			<u>.</u>						
									<u> </u>					

Picklist Print

January 27, 2010 11:25:57 AM

Work Order ID: 55680

D3573-1 Parent Item:

Parent Item Name: Adapter

IPP Rev:A New Issue 07-01-29 JLM Comments:

Start Date: 1/27/10

Start Qty: 10.00

Required Date: 2/05/10

Page 1

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6B0.625X02.50		Purchased	No			100	f	4.2984	3.0737			

6061-T6 Bar .625 x 2.50

Loc Qty Warehouse

Loc Code

Location

Main Warehouse

MAT

4.2984

A 10.10.29

4.2984

	•								,		
W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
······································		,									
Part No	•	PAR #:	Fault Category: NCR: Yes No [DQA: Date:			
		esolution:									
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	l)					
DATE	STEP	Description of NC		Corrective Action Section		Verific	· cation	Approval	Approval		
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector		
				1300 1337 A A 31							
!									ŀ		

DART AEROSPACE LTD	Work Order:	35680
Description: Adapter	Part Number:	D3573-1
Inspection Dwg: D3573 Rev: A		Page 1 of 1

	FIRS	ST ARTICLE	INSPECT	ION CH	IECKLIST		
		X First Art	icle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspecti	1 1 1	omments
3.31	+/-0.030	3.309					
2.69	+/-0.030	2.685		_			
2.31	+/-0.030	231		_			
1.600	+/-0.010	1,6					
0.36	+/-0.030	,36					
1.19	+/-0.030	1,19					
2.38	+/-0.030	2.373	1.				
1.420	+/-0.010	1,420					
0.48	+/-0.030	,48		-			
R0.63	+/-0.030	1.63					
R0.13	+/-0.030	1.13		_			
R0.02	+/-0.030	1,005					
Ø0.209	+0.005/-0.001	,2095					
Ø0.201	+0.005/-0.001	.202					
0.520	+/-0.010	,517					
Ø0.500 x 0.400	+/-0.010	,5×400					
Ø1.000 x 0.100	+/-0.010	1.00 x-100					
Measured by:		Audited by:	26		Prototype	Approval:	N/A
Date:	10.90.29	Date:	19/02/2	9		Date:	N/A
Rev Date	Change					Revised by	Approved
A 07.04.04	New Issue				_	KJ/JLM 🛠	- [41]

Dart Aerospace

W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-11						
	!								
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Resolution: Disposition: QA: N/C Closed:								
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		on B	Verific	cation	Approval	Approval	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
				•					
				,					



DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECK	ED	APPROVED.	DRAWING NO.		REV. A			
F	214	1	D3573	S	HEET 1 OF 4			
DATE		· · · · · · · · · · · · · · · · · · ·	TITLE		SCALE			
07.02.19			ADAPTER		1:1			
REV		DATE		DESCRIPTION				
Α		07.02.19	NEW ISSUE		SELV.			

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE R0.63 WORK ORDER Ø0.209 (DRILL #4) THRU __ Ø 0.500 ▼ 0.400 1.19 (4 PLACES) ϕ 0.201 (DRILL #7) THRU C'SINK ϕ 0.385 X 100° 3.31 (REF) 2.69 GRAIN DIRECTION 2.31 1.600 R0.02 (TYP) \oplus 0.36 0.520 0.48 1.420 R0.13 (TYP) 2.38

D3573-1 ADAPTER \

<u>NOTES</u>

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

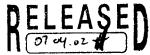


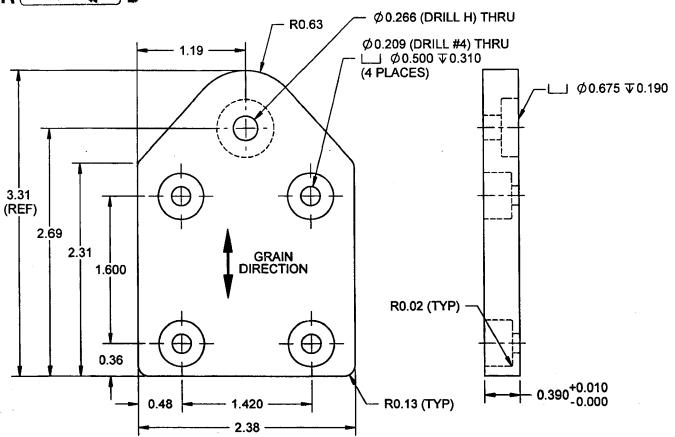
W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			=1+0								
	<u> </u>	-									
		PAR #:	Fault Categ	_ NCI	R: Yes	No DO	QA:	_ Date: _			
		esolution:	Disposition:			N/C	Closed: _	Date:			
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NC	R)				
DATE	CTED	Description of NC			tion B		Veri	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign Dat	& Se	ction C	Chief Eng	QC Inspector	
									i		



DESIGN	DRAWN BY	DART AERO HAWKESBURY, ON	
CHECKED APPROVED		DRAWING NO.	REV. A SHEET 2 OF 4
DATE	2.19	TITLE ADAPTER	SCALE 1:1

W/0 55680





D3573-3 ADAPTER

NOTES: 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

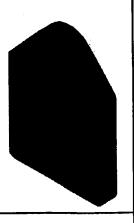
4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



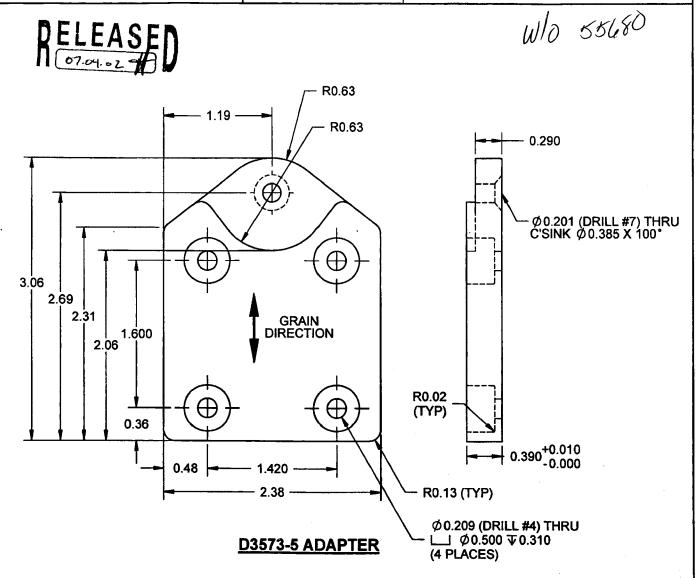
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



W/O:										
W/O:			WC	RK ORDER CHANGE	S					
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			···-	· · · · · · · · · · · · · · · · · · ·						
Part No:		PAR #:	Fault Cate	NCR: Yes No DQA: Date:						
Resolution:			Disposition: Q			A: N/C Closed: Date:				
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCF	₹)				
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	tion Approval		
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a Date	gn & Section C		Chief Eng	QC Inspector	
									l.	



DESIGN	DRAWN BY	DART AERC HAWKESBURY, O	OSPACE LTD NTARIO, CANADA
CHECKED PH	APPROVED	DRAWING NO.	REV. A
DATE	100	TITLE	SHEET 3 OF 4 SCALE
07.0	02.19	ADAPTER	1:1



NOTES: 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

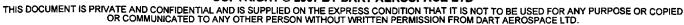
3) TOLERANCES ARE PER DART QSI 018 UNLESS OF THE WAS ENTED.

4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

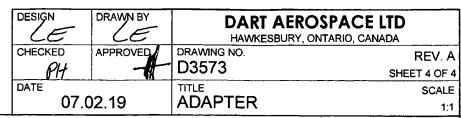
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



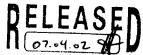


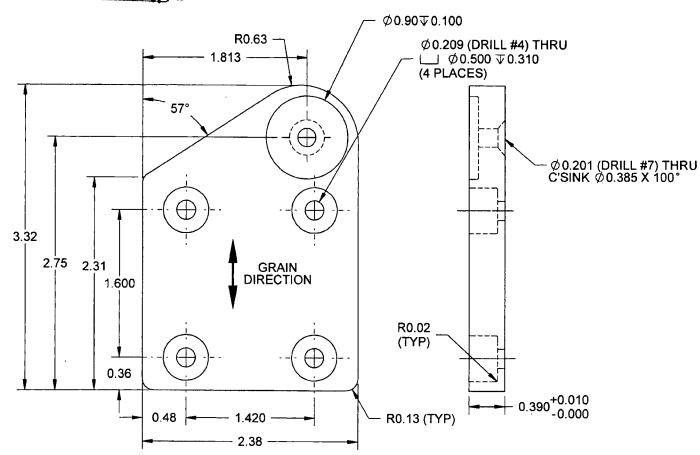
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date Resolution: Disposition: QA: N/C Closed: Date NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Corrective Action Section B										•		
Part No:PAR #: Fault Category: NCR: Yes No DQA: Date Resolution:Disposition: QA: N/C Closed: Date NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Section A Confective Action Description Sign & Section C Chief En Prod Mg Verification Approximately Approx						S	ORK ORDER CHANG	W			W/O:	
Resolution:	Approvar	Approval Chief Eng / Prod Mgr	Qty	Date	Ву	E	PROCEDURE CHANGE				DATE STEP	
Resolution:												
Resolution:							·					
Resolution:												
Resolution:												
Resolution:		,						· · · · · · · · · · · · · · · · · · ·			<u> </u>	
NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Section A Initial Action Description Sign & Section C Chief Er		_ Date:	\:	o DQ A	Yes N	NCR:	egory:	PAR #:				
DATE STEP Description of NC Section A Port Initial Action Description Section B Verification Section C Chief Er								·	Res			
DATE STEP Description of NC Section A Initial Action Description Sign & Verification Approx					NCR)	NCE (DER NON-CONFORMA	ORK ORI	V		NCR:	
Section A Initial Action Description Sign & Section C Chief Er		Approval						Description of NC	STEP	DATE		
	g QC Inspector	Chief Eng	on C	Section					Section A	J.E.	DAIL	
				!				1				
							**************************************		111700000			





W/0 55680





D3573-7 ADAPTER (SHOWN) D3573-8 ADAPTER (OPPOSITE)

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

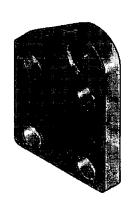
(REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



COPYRIGHT © 2007 BY DART AEROSPACE LTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						į						
										1		
						İ						
			***		-							
Part No:		PAR #:	Fault Category:			Yes N	10 DQ	Date:				
			Disposition:									
NCR:		1	WORK ORDI	ER NON-CONFORM	ANCE (NCR)						
		Description of NC	Corrective Action Section				Verification		Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector		
										1		
					i.		:					